OPERATING INSTRUCTIONS

for the heat press

Secabo TP10

Congratulations on purchasing a Secabo heat press!
Please read these operating instructions carefully so you can start production with your press without problems. Reproduction of these operating instructions in any form requires the written approval of Secabo GmbH. We reserve all rights to change technical data and product features. Secabo GmbH does not assume any liability for direct or indirect damage resulting from use of this product.

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Brief overview

Secabo TP10 pneumatic heat press

The newly developed heat press Secabo TP10 is for professional textile printers of large objects: With an extra large work area of 75 x 105 cm, the transfer press is particularly suitable for heat transfers on expansive media such as flags, sheets or room dividers made of textile. The base plate acts as a drawer, which allows comfortable arranging of transfer objects and can be handled despite its size with little effort. The pressure of the TP10 transfer press is produced by compressed air, which means working with consistent and reproducible results. The pneumatic head of the heat plate allows due to vertical contact pressure a flawless transferring of various materials without displacement effects, etc. The Secabo TP10 heat press with a heat output of 5.1 kW is suitable for all standard transfer processes and thus can be used in almost all areas of technology transfer.

Short overview Secabo TP10 transfer press

- Pneumatic heat press for large batches.
- Fast and simple time and temperature specification, comparison of target and performance values with digital display.
- Flexibly adjustable contact pressure by manometer with oil and water separator.
- Two-hand operation emergency off switch, emergency-stop for pneumatic cylinder with pre-press function.
- CE-certificate, RoHS-certificate, inspected according to German safety standards.

Safety Precautions

Please read these instructions and safety precautions carefully before using your press for the first time!

- Never reach into the heat press with your hands when it is connected to the power supply, particularly when it is switched on and heated up – danger of severe burns!
- Never manipulate the buttons for two-hand operation, the emergency off switch or another component on the transfer press.
- Never open the housing or attempt to modify the machine yourself.
- In case you are requested by the Secabo customer support to open the heating plate cover, please make sure you are wearing respiratory protection and only touch the contained insulation wool with gloves. Any disposal of the wool must be contained in a closed bag.
- Ensure that liquids and metal objects do not get into the inside of the heat press.
- Ensure that the power socket used is grounded. Note that it is only permissible to operate a heat press from a power socket protected by a ground fault protection switch.
- Disconnect machine from power outlet when not in use!
- Never operate the heat press within the reach of children and never leave the machine unsupervised when switched on.

- Ensure that the machine is used only in dry rooms.
- Pay attention that the used compressor is attuned to the air consumption and the pressure need of the TP10 in tank volume and maximum pressure. Only use pressure tanks that possess the necessary TÜV-certificates.

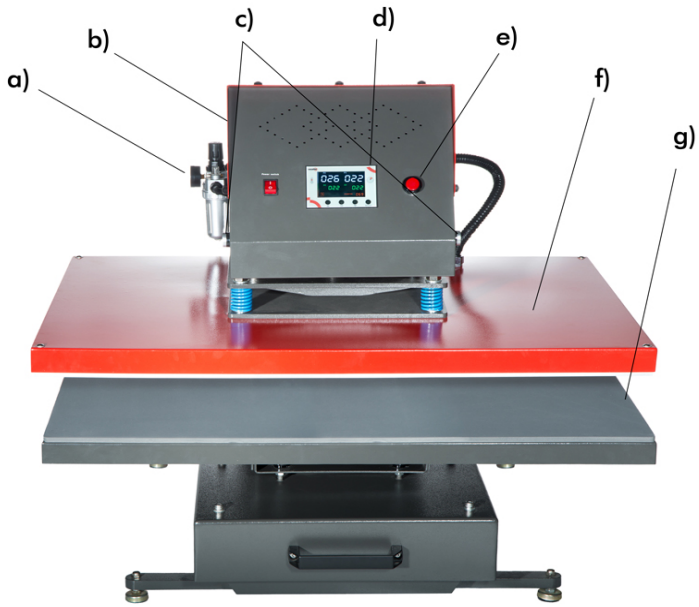
If you cannot observe one or more of the safety precautions above, or if you are not sure whether all points are satisfied, please contact our Technical Support Department.

Scope of Delivery

Before starting work, please check whether the following items are all present:

Article	Quantity
TP10 heat press	1
Pneumatic adapter for air compressor connection	1
Instruction manual	1

Machine description



a. manometer, oil- and drain valve
b. rocker switch, fuse, connecting cable (back side, not shown)
c. two hand control buttons
d. time- and temperature controller

e. emergency stop for pneumatic system, pre-pressing button
f. heating plate
g. base plate - retractable as a drawer

Controller

With a large digital controller, temperature (°C und °F) and pressing time can be adjusted. The green digits are showing the theoretical value, the white digits are showing the actual value. A counter (at the right bottom) counts the number of transfers that have already been made during the current session. The counter can be reset at any time.

Operation

Pneumatic connection

- Connect the TP10 to your air compressor with the included pneumatic adapter. Insert the tube of the supplied adapter in the pneufit-connection at the rear of the TP10 heat press. The other end of the adapter will be connected with the compressor. Charge the compressor with 6-8 bar, up to 10 bar is possible.
- Set the desired pneumatic pressure on the manometer of the TP10 by pulling up the cap at the top end and then turning it. After the pressure is set, push the cap back down. The set pressure should be lower than on the manometer of the compressor. Commonly used pressures are between 3 and 6 bar.

Power supply

- Connect the heat press to a 400 V power socket (3P+N+PE) using the connection cable supplied. It is recommended to have the TP10 connected by an electrician. It is mandatory to assign the right lead of cables.
- Switch on the press with the red rocker switch.

Operation and setting

- After a short self-test lines appear in the display.
- Press the OK button.
- Use “UP” or “DOWN” to set °C or °F and press OK.
- Use “UP” or “DOWN” to set the desired temperature and press OK.
- Use “UP” or “DOWN” to set the desired time and press OK.
- The press is heating up to the desired temperature

Operating transfers

- Pull out the base plate at the front side with the centered handle and put on the transfer objects. Afterwards push the base plate completely backwards.
- Now use both hands to push each one of the two buttons on the left and right of the press head to lower the heating sheet.
- The timer starts running as soon as the press is closed.
- After the set time has expired, the TP10 opens automatically.
- By pressing the red button next to the controller the transfer process can easily be stopped at any time - e.g. for pre-pressing garments
- The settings cannot be changed during pressing.
- Each time the pressing process is completed, the counter display increments by one after the set time has expired.

Note: Please note that a certain time is required before the press cools down after it is switched off.

Maintenance and cleaning

Maintenance work should always be accomplished with the press switched off and cooled down. The plug must first be disconnected from the power socket. Consult Technical Support before carrying out any maintenance work.
Clean the press regularly with a soft cloth and mild household cleaner to remove adhesive residues etc. Never use scouring sponges, solvents or gasoline!
Clean the drain valve by draining oil and water through the drain valve.

Recommended times and temperatures

These values are only guidelines; they can vary from material to material and should always be checked before pressing.

Material	Temperature	Pressure	Time
Flock film	170°C - 185°C	light - medium	25s

Flex film	160°C - 185°C	medium-high	25s
Sublimation flex	180°C - 195°C	medium-high	10s - 35s
Sublimation ceramic mugs	200°C	medium-high	150s - 180s
Sublimation on tiles	200°C	high	120s - 480s (depending on thickness of material)
Sublimation on jigsaw puzzles	200°C	light - medium	50s
Sublimations mousepads	200°C	medium	20s - 40s
Sublimation on textiles	200°C	medium-high	30s - 50s
Sublimation on metal plates	200°C	high	10s - 50s (depending on thickness of material)

Important note: You should carry out your own tests with the transfer material and backing to be used before starting production. The values given above and the manufacturer's own figures are only intended as a guide. You should establish the washability and behaviour during transfer in your own tests.
The recommended values do not imply a guarantee. The user is responsible for determining and using the appropriate setting for his particular conditions.

Note for textile work: After pressing, allow textiles to cool down before removing any type of backing from the transfer material. The hot glue in the transfer material develops its adhesive force only in the cold state. If the adhesive does not stick in the cold state, it may have been pressed too cold or for too short a time.

Technical data

Heat press	**TP10**
Working Area	105cm x 75cm
Max. temperature	225°C
Max. time setting	999s
Max. pressure	150g/cm², max. 10bar
Pressure setting	Setting of pneumatic pressure on the manometer
Power supply	3P+N+PE, 5,1kW. It is recommended to have the TP10 connected by an electrician.
Environment	+5°C - +35°C / 30% - 70% humidity
Weight	190kg
Dimensions (B x H x T)	110cm x 90cm x 140cm

Konformitätserklärung - Statement of Conformity

Hiermit erklären wir in alleiniger Verantwortung, dass das unter „Technische Daten“ genannte Produkt mit den Bestimmungen der folgenden EG-Richtlinien und Normen übereinstimmt:

We herewith declare under sole responsibility that the under „technical data“ mentioned product meet the provisions of the following EC Directives and Harmonized Standards:

- EG-Richtlinien / EC Directives:
- 2006/95/EG Niederspannungsrichtlinie / 2006/95/EC Low Voltage Directive
- 98/37/EG Maschinenrichtlinie (2006/42/EG ab 29.12.2009) / 98/37/EC Directive on machinery (from 2009-12-29: 2006/42/EC)
- Norm / Standard: EN 60204-1:2006

Technische Dokumente bei / Technical documents at:
Secabo GmbH, Hochstatt 6-8, 85283 Wolnzach, Germany

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